

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86800

86800

Page 2

July-06-12 2:54:49 PM

Item ID: D3372-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Slider Body
 Start Date: 7/06/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/24/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00	SL	12-08-14					
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

4/ 12-8-15
 4x 6 12/08/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 86800

86800

Page 3

July-06-12 2:54:49 PM

Item ID: D3372-7 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Slider Body
 Start Date: 7/06/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/24/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Small Fab	0.00							
160									
Small Fab	Memo	0.00							
Small Fab	Fabricate D3372-9 using AN6-36A bolt. Cut to length, then mill slot when bolt and D3372-7 are assembled as per Dwg D3372.								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
180									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:30 OVEN TEMPERATURE: 400 FINISH TIME: 3:25 - 0F								

M N3645

MF
 12/08/20

Dart Aerospace Ltd

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Page 4

July-06-12 2:54:49 PM

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 Start Date: 7/06/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/24/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>G.A.</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MCJ 12/08/21
 MCJ 12/08/21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

July-06-12 2:54:49 PM

Page 1

Work Order ID: 86800

Parent Item: D3372-7

Parent Item Name: Slider Body

Start Date: 7/06/12

Required Date: 8/24/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.01.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-36A Bolt		Purchased	No			110	Each	47.0000	1	4			

Location	Loc Qty	Loc Code
ST342 1122416	47	
118422	2	
119449	1	
120187	4	
120423	40	

4 12-08-16

M6061T6B1.500X01.250

Purchased

No

160

f

19.3170

0.3833

1.6138948

6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code
MAT003	7.317	
118071	0.112	
119513	0.945	
121660	6.26	
MAT004	12	
122081	12	

1.614 FK 12/08/10

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	8500
Description: Slider Body		Part Number:	D3372-7
Inspection Dwg: D3372	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.005	0.751	✓		Vern	GA-01
0.313	+/-0.005	0.314	✓		D-6	BA-08
2.108	+/-0.010	2.105	✓		H-6	31006
1.50	+/-0.030	1.504	✓		Vern	GA-01
0.63	+/-0.030	0.628	✓		"	"
4.31	+/-0.030	4.311	✓		"	"
1.19	+/-0.030	1.188	✓		"	"
0.613	+/-0.010	0.614	✓		"	"
2.938	+/-0.010	2.938	✓		"	"
1.375	+/-0.010	1.374	✓		"	"
0.200	+/-0.010	0.208	✓		"	"
Ø0.323	+0.005/-0.000	Ø0.327	✓		"	"
0.500	+/-0.010	0.495	✓		D+6	GA-08
0.881	+/-0.010	0.883	✓		"	"

Measured by:	D.A.	Audited by:	SL	Prototype Approval:	N/A
Date:	12/08/13	Date:	12-08-14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	09.05.04	Dimensions revised	KJ/DD	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

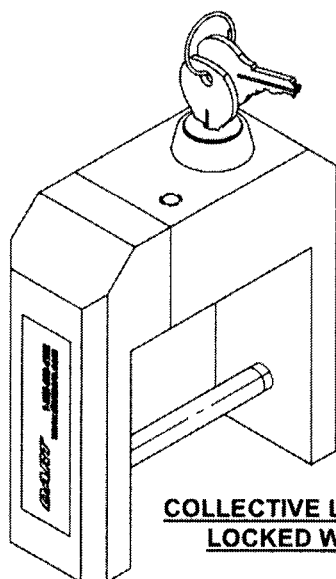
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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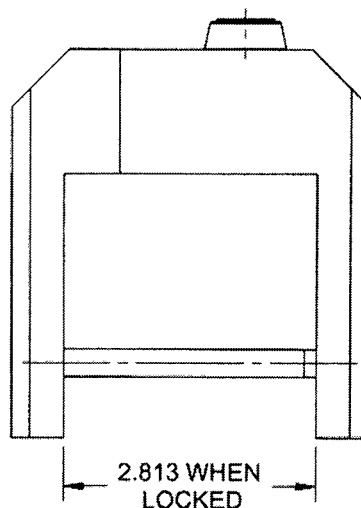
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



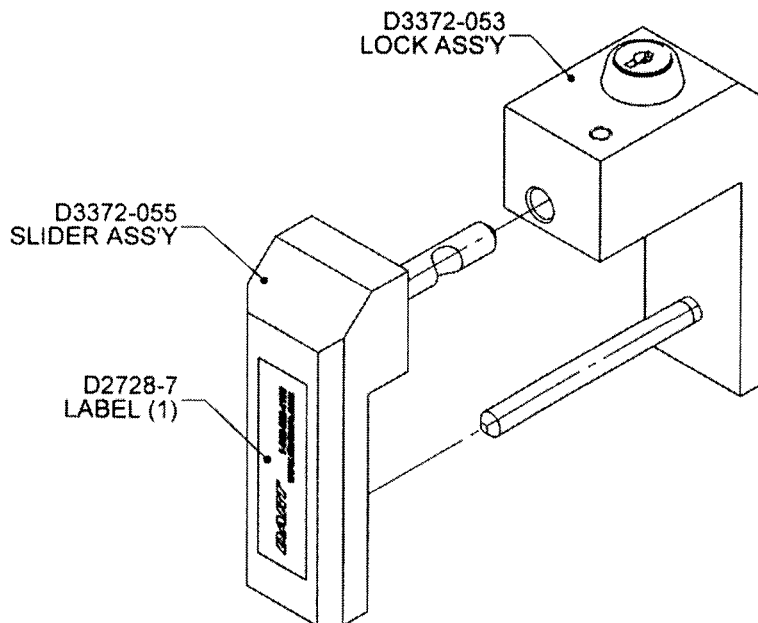
**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**

SHOP COPY
RETURN TO:
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *86800*

012-07-9



2.813 WHEN
LOCKED



RELEASED
[Signature]
05/04/28

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

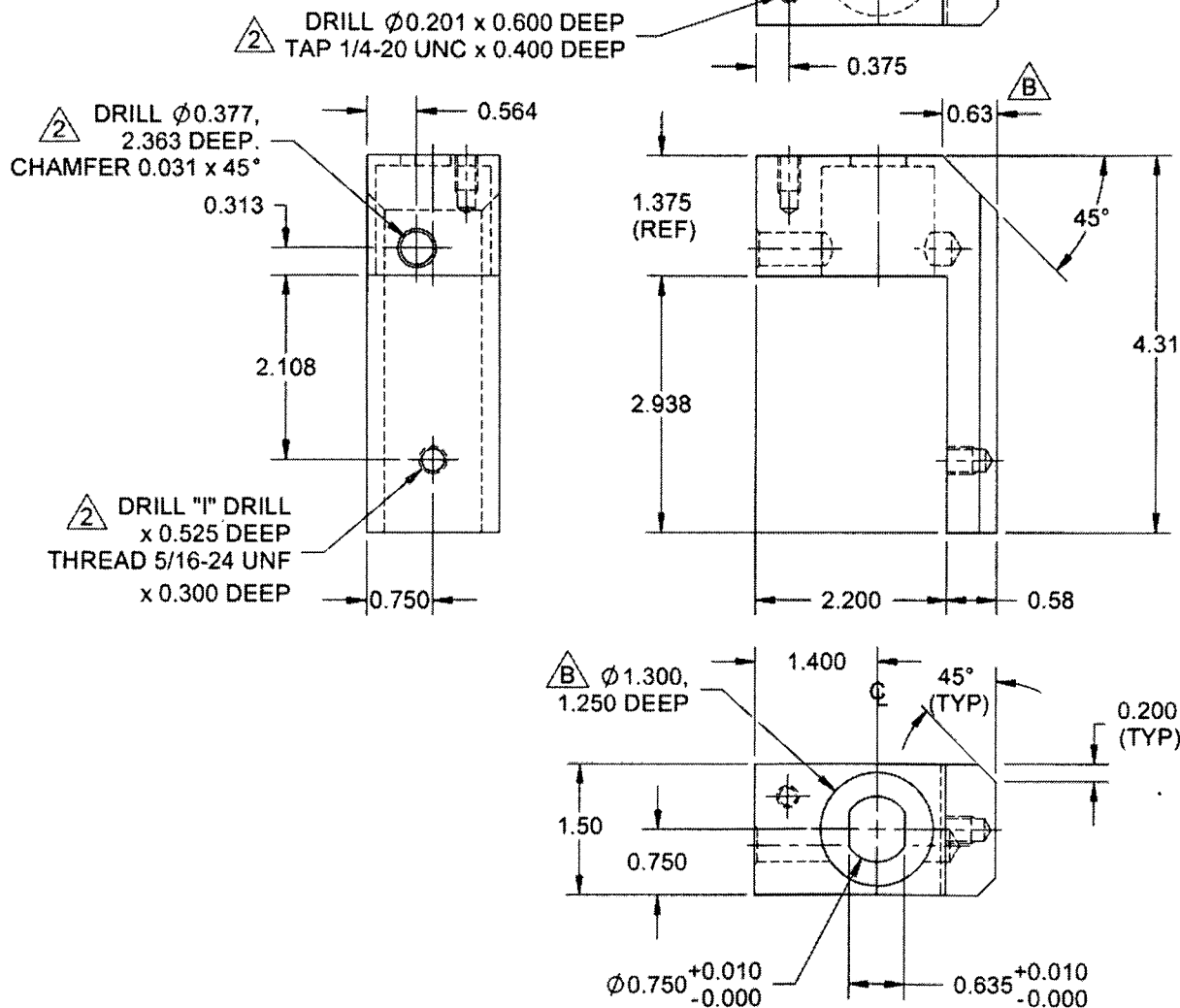
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3372	REV. B SHEET 4 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

RELEASED
05/04/23



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NOTE: Date & initial all entries

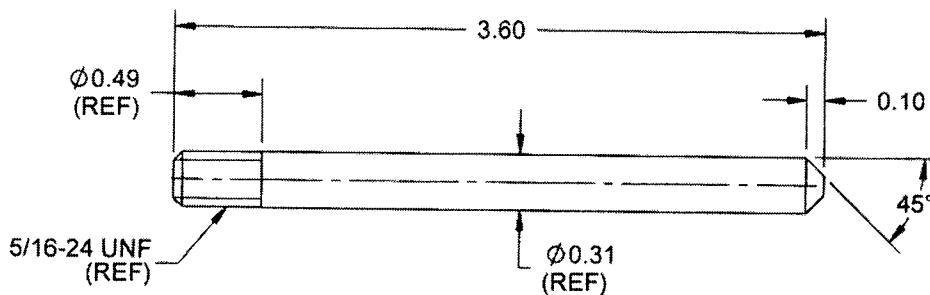


DESIGN <i>3</i>	DRAWN BY <i>3</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TH</i>	APPROVED <i>MB</i>	DRAWING NO. D3372	REV. B SHEET 5 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

86800

SPECIFICATION CONTROL DRAWING

RELEASED
MB
05/04/23



D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

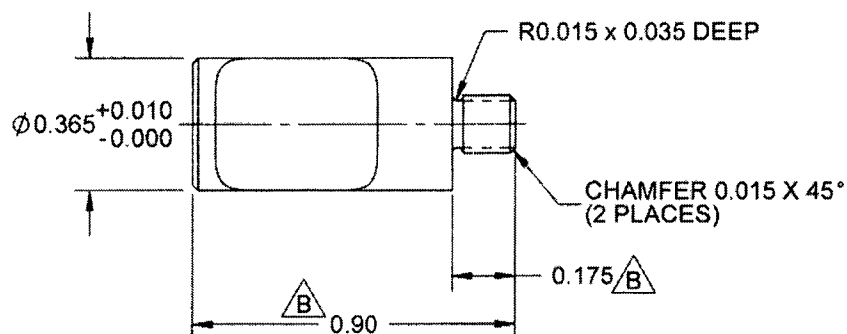
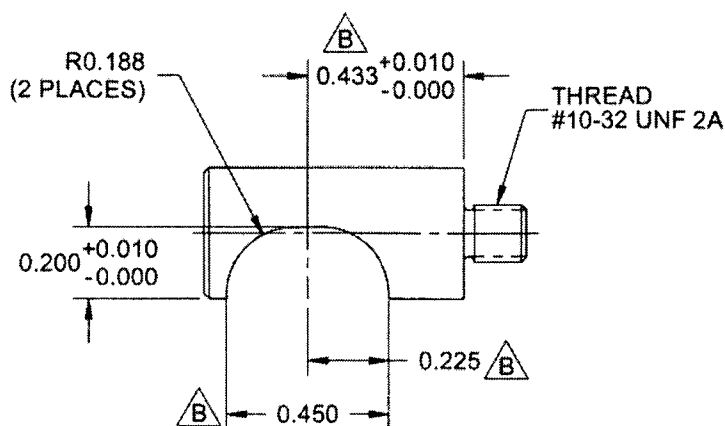
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 6 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/28
86500



D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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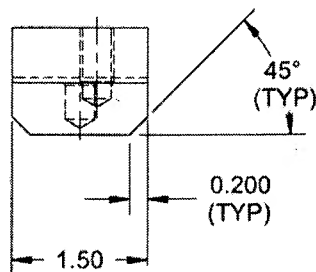
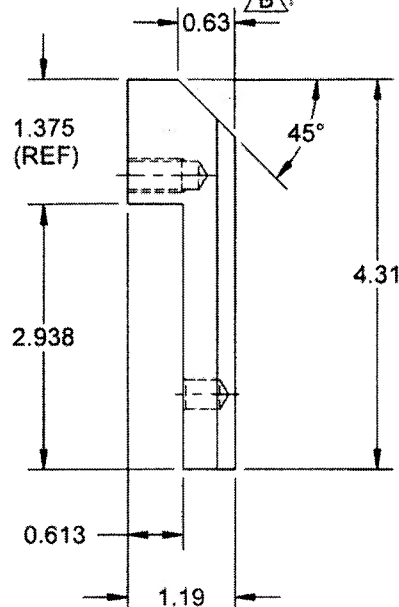
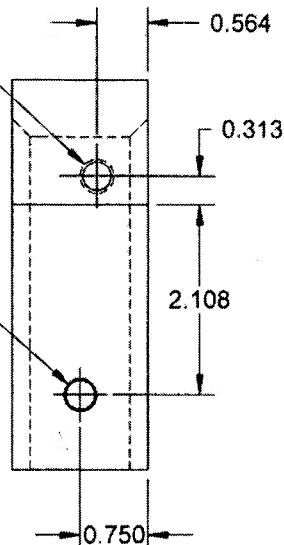
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 7 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

DRILL $\phi 0.332$
("Q" DRILL) x 0.881 DEEP,
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL $\phi 0.323$
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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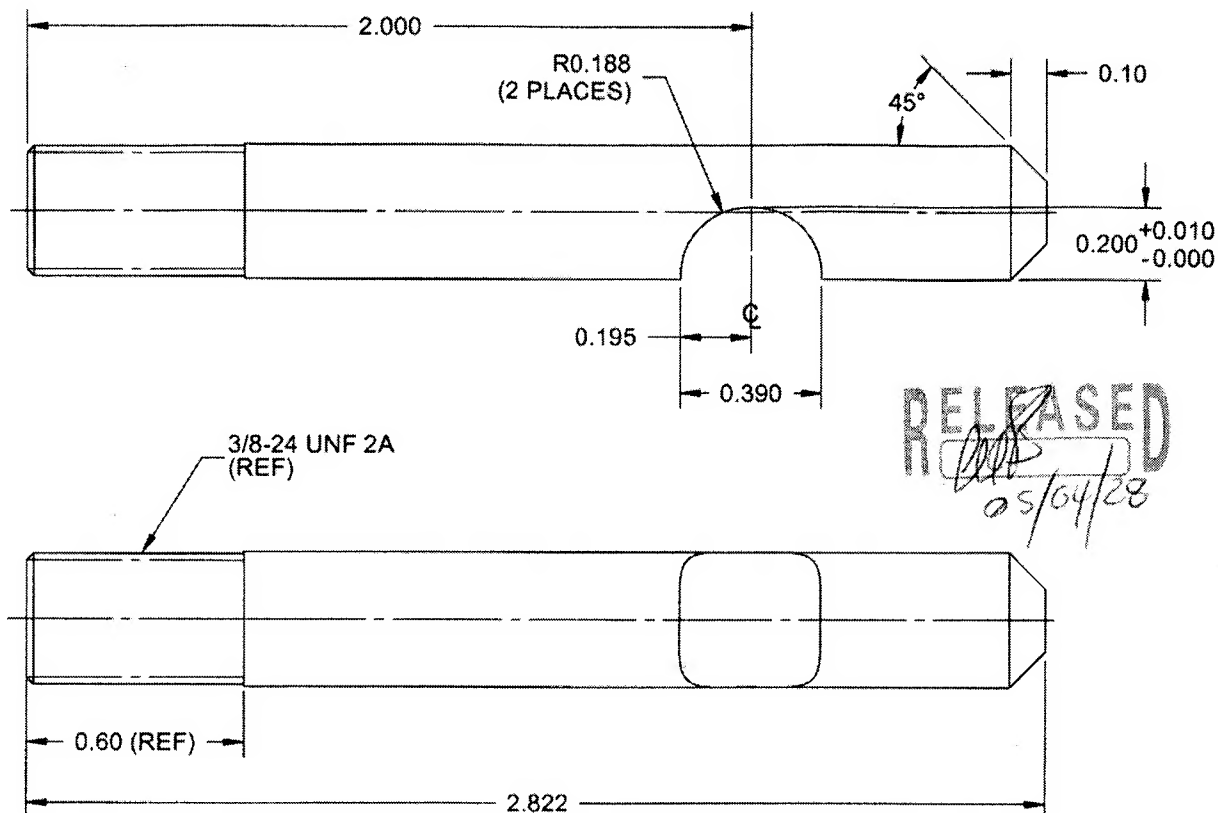
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING

46800



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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